

shp 21/03

ASAO

Work Order ID 67383

PRELIMINARY ISSUE

Thursday, March 17, 2011 10:19:25 AM

Page 1

Item ID: D4330-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4330

PAT PAC

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (made from D4330-1)

Dwg Rev: PAC

Prog Rev: PAC

2-Deburr if necessary

~~11 03 17 (1)~~
11 03 18 (1)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

~~11 03 17 (1)~~
11 03 18 (1)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Inspector PAC
Dwg only
8/16/18 NL

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Page 2

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Required Date: 3/18/2011 Req'd Qty: 1.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg
NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JB 11/03/21

1/0.00 - inspected to Part
Dwg only
8/10/21 (H)

1 BR 11-3-21.

Work Order ID 67383

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Page 3

Item ID: D4330-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951</i> Memo POWDER COAT: Start Time: <i>2:10</i> Oven Temperature: <i>320°</i> Finish Time: <i>2:40</i>	0.00 0.00				<i>1</i>		<i>BL 11-3-21</i>	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>(14)</i> <i>= 7 m-h 11/03/21</i>
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<i>SO 104477</i> <i>11/3/21</i>

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Thursday, March 17, 2011 10:19:25 AM

Page 4

Item ID: D4330-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CL11/03/21

R282370

POSITIVE RECALL

EFFECTIVE 11.03.17

AUTH

RELEASED

DATE

DATE

RELEASED

AUTH

EFFECTIVE

POSITIVE RECALL

Picklist Print

Thursday, March 17, 2011 10:19:23 AM

Page 1

Work Order ID: 67383

Parent Item: D4330-2

Parent Item Name: Airframe Bracket



Start Date: 3/17/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.17 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

98.5000

0.265

0.278947



6061-T6 .063 Sheet

W 11.03.17

Location

Loc Qty

Loc Code

MAT

64.6

~~116308~~

28.6

~~116623~~ X

36

MAT21

33.9

~~113608~~ X

33.9

0.557894

D4330-2 AIRFRAME BRACKET, RH
D4330-1 AIRFRAME BRACKET, LH (OPPOSITE)

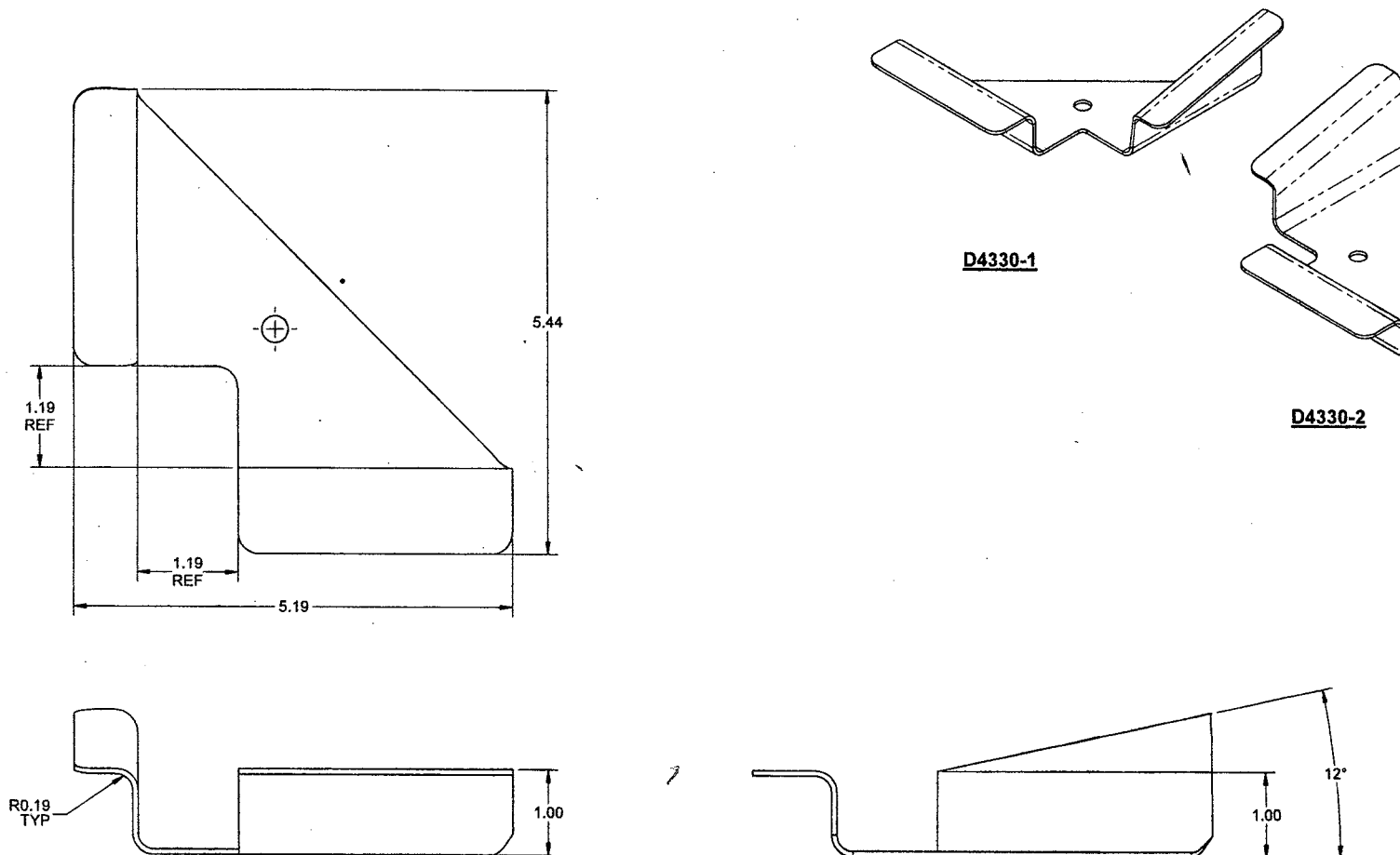
PRELIMINARY ISSUE

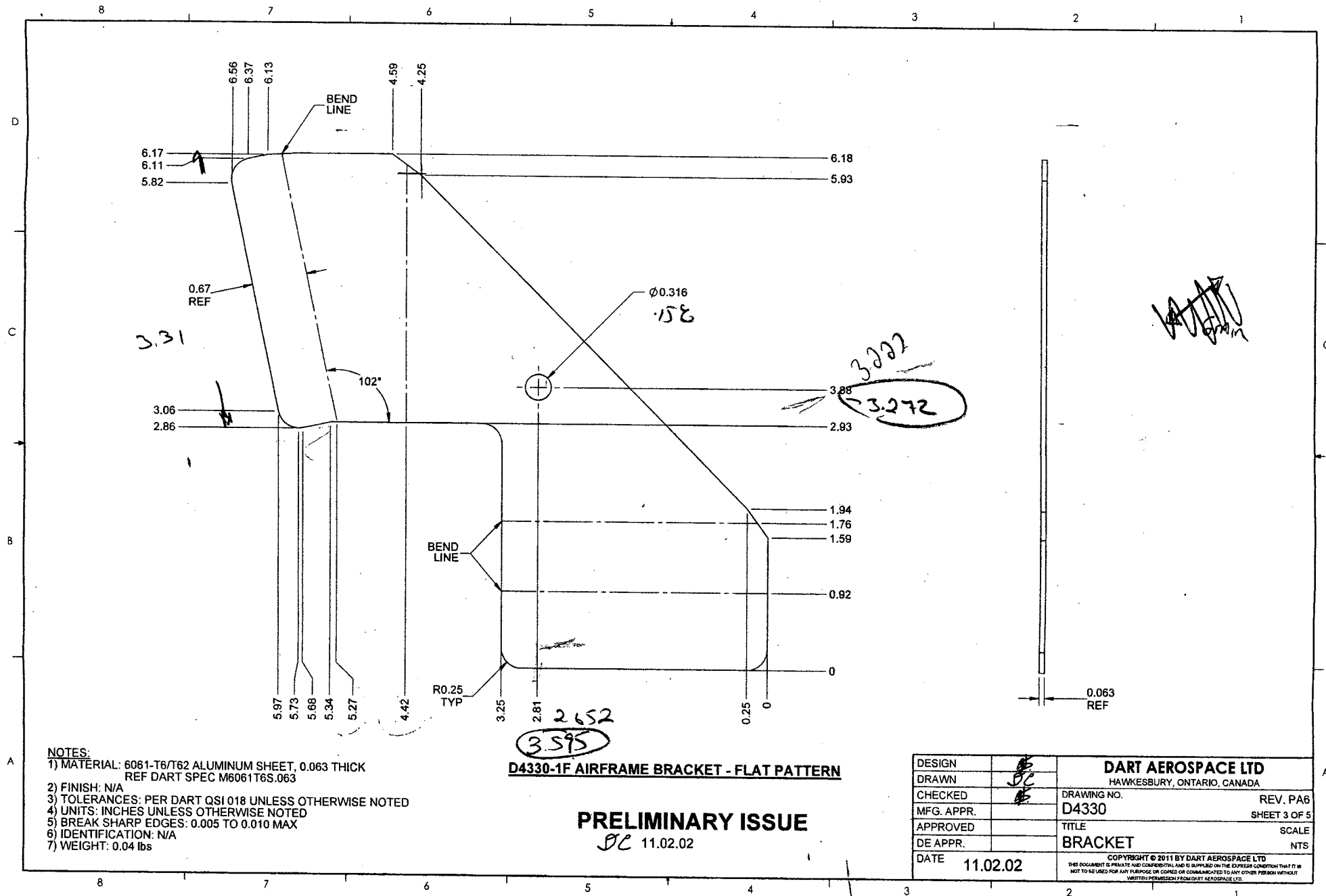
BC 11.02.02

NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. PA6
MFG. APPR.		D4330	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.02.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





DART AEROSPACE LTD

Work Order: 67383

Description: Air frame Bracket (Preliminary)

Part Number:	D4330-2
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Inspection Dwg: 4330 , Rev: PA6

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

[illegible]

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

Date:

Rev

Date _____

Change

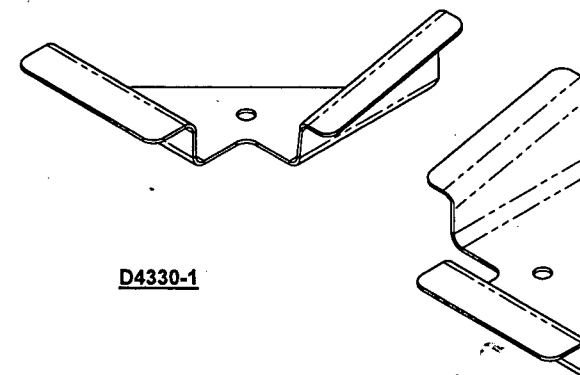
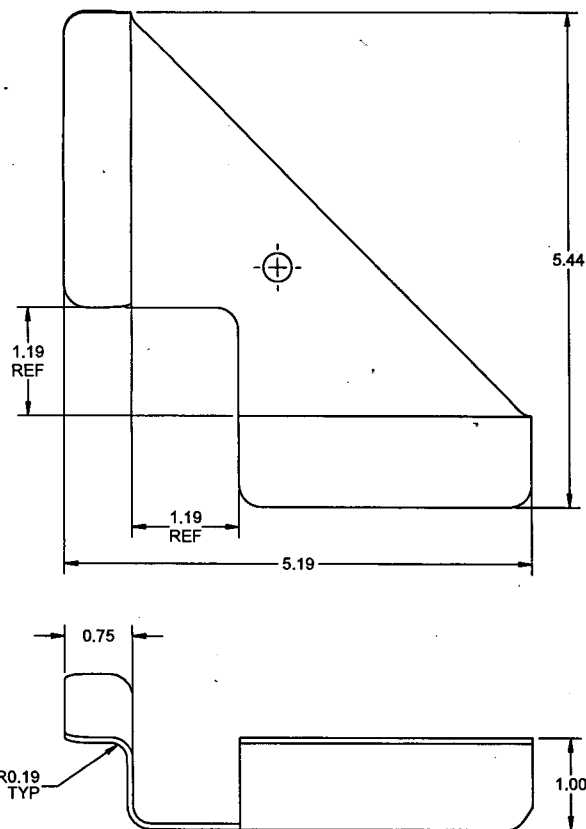
A

New Issue

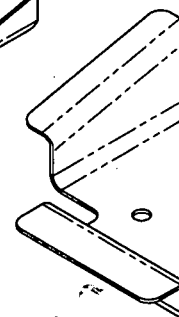
Revised by

KJ/JLM

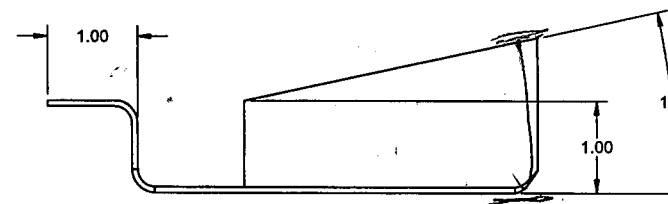
Approved



D4330-1



D4330-2



D4330-2 AIRFRAME BRACKET, RH
D4330-1 AIRFRAME BRACKET, LH (OPPOSITE)

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SC 11.02.02

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DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. PA7
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